

Date: Monday, 11/6/2006 2:39:42 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 29338		
Estimate Number	: 10618		
P.O. Number	: <i>N/A</i>	Part Number	: D265637
This Issue	: 11/6/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2656 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 27473	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 11/22/2006 Qty: 20 Um: Each
Checked & Approved By	: <i>[Signature]</i> 06 11 07		
Comment	: Est Rev: D 02.10.25 Re-format KJ Est Rev: E 06-06-12 Now on Waterjet JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.5650 sf(s)/Unit Total : 11.3001 sf(s)
 1010/1025 .040" SHEET
 (M1010S20GA)
 Batch: *M103258*

*ML 07 02 01**(20)*

2.0	WATER JET	FLOW WATER JET
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✓



Comment: FLOW WATER JET
 1-Cut as per Dwg D2656
 Dwg Rev: *D*
 Prog Rev: *D*

*ML 07 02 01**(20)*

2-Deburr if necessary

[Signature]

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

*ML 07 02 01**(20)*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ML 07/02/05 (20)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary.

SP John 07/02/06 20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: FD Date: 07/02/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:39:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 29338

Part Number: D265637

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326.

2- Identify as D2656-37

SB 07/02/07 20

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0702-08 20

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

MR / Y 07/02/09

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/02/09 (20)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP21

Y 07/02/09 x 20

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(20) 07/02/12

Job Completion



u 07.02.09

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

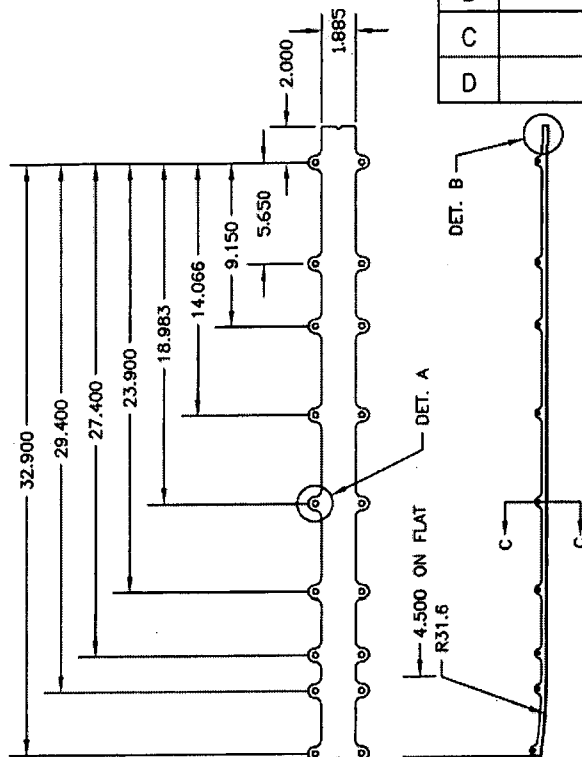
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

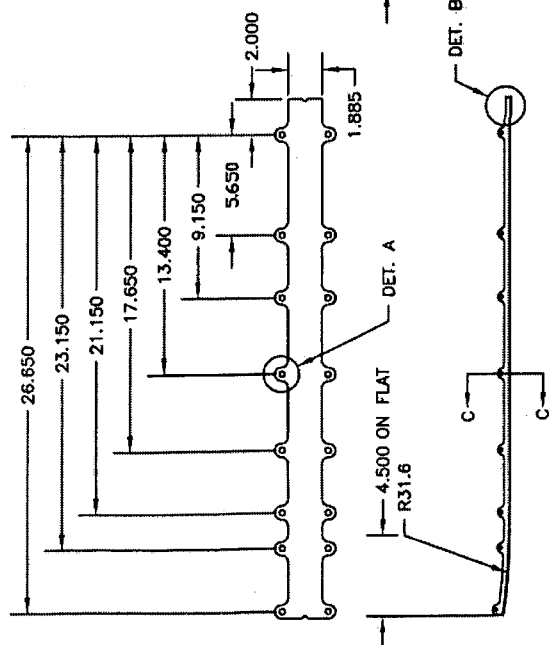


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DS		CP		PORT HADLOCK, WA	
CHECKED		APPROVED		DRAWING NO.	REV. D
				D2656	SHEET 1 OF 4
DATE				TITLE	SCALE
05.08.17				WEARSHOE	1:10
A	97:03:25			NEW ISSUE	
B	97:06:02			CHANGED TABS	
C	97:06:26			R31.6 WAS R19.5	
D	05.08.17			ENLARGE ALL HOLES TO IMPROVE FIT	

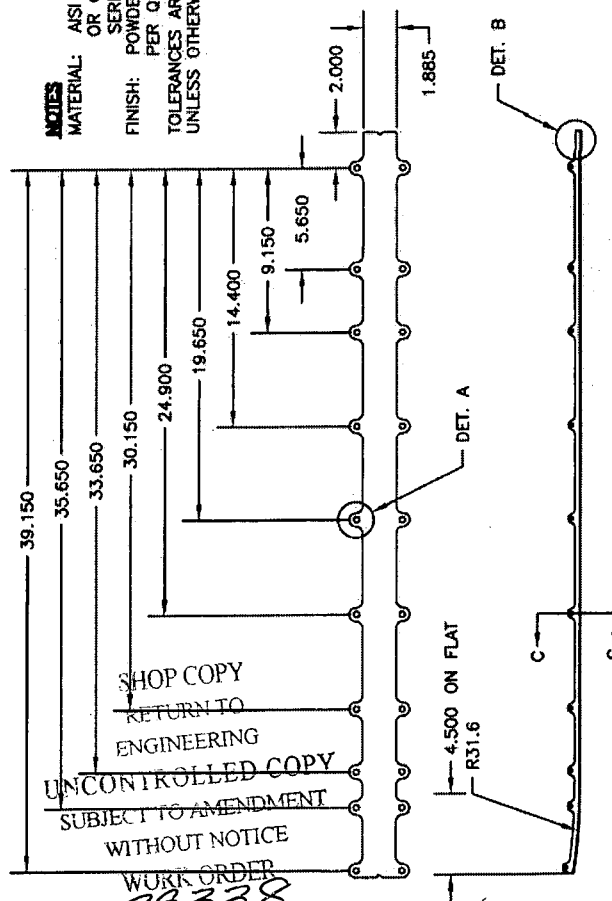
D2656-13



D2656-11



D2656-15



NOTES:
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 39W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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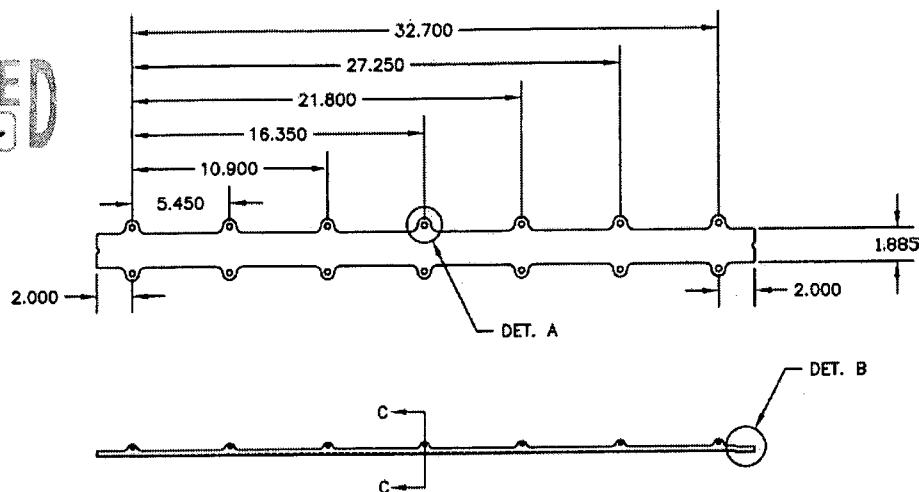
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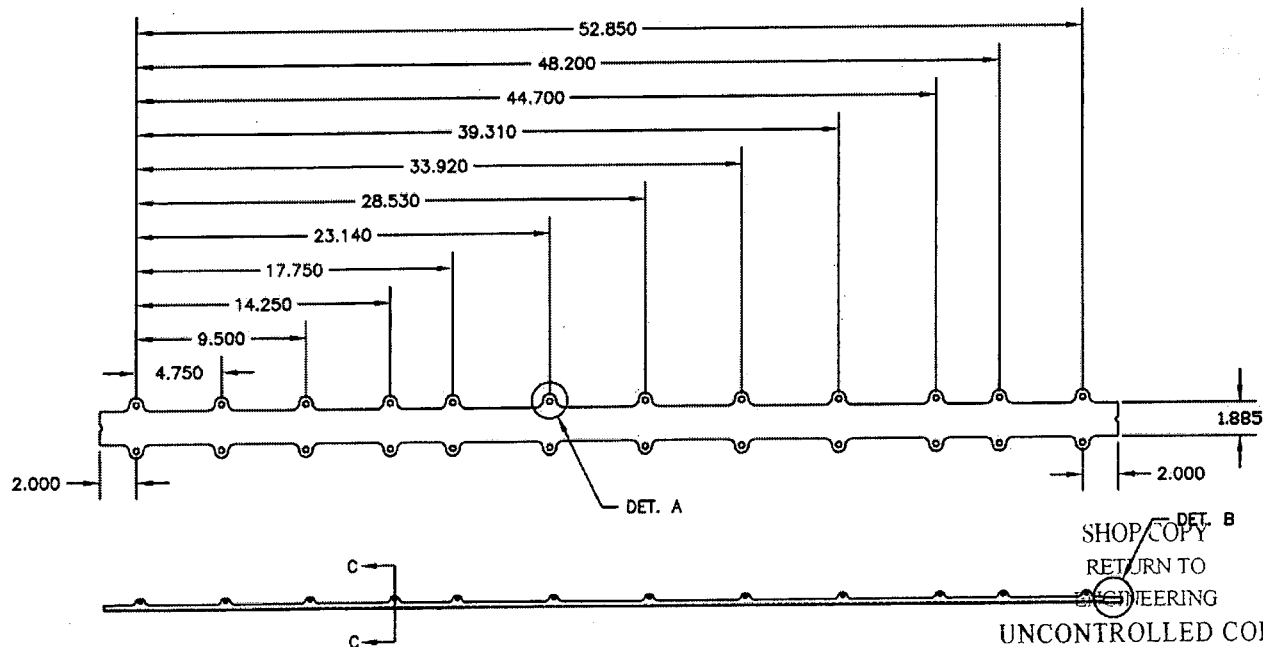
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

RELEASED
05-09-06

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
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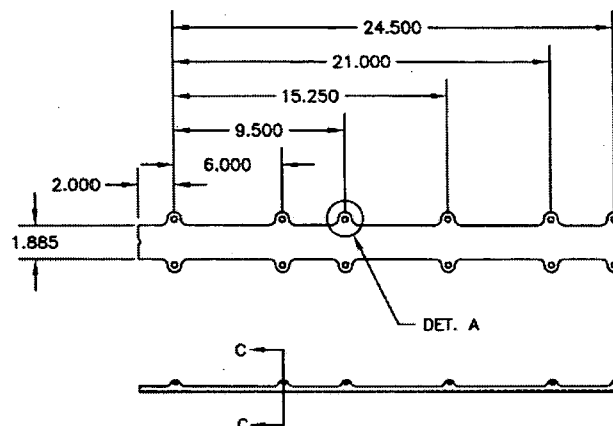
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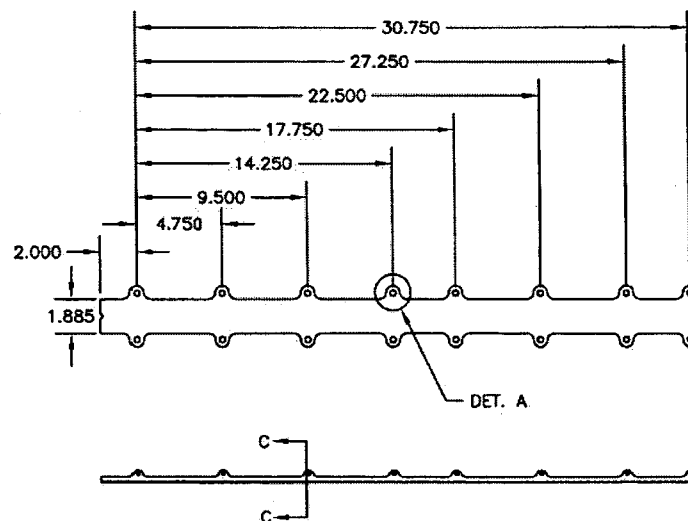
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DATE	05.08.17	TITLE	WEARSHOE	REV. D
		DRAWING NO.	D2656	SHEET 3 OF 4
		SCALE	1:10	

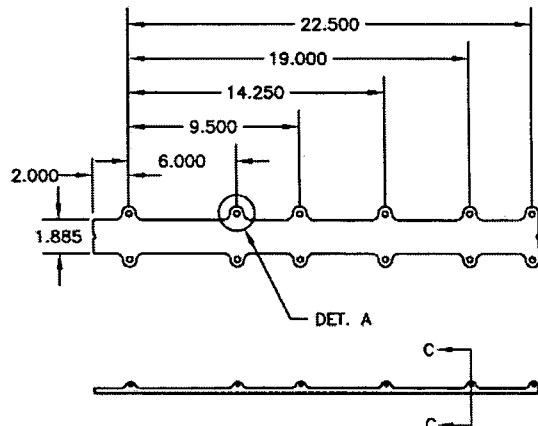
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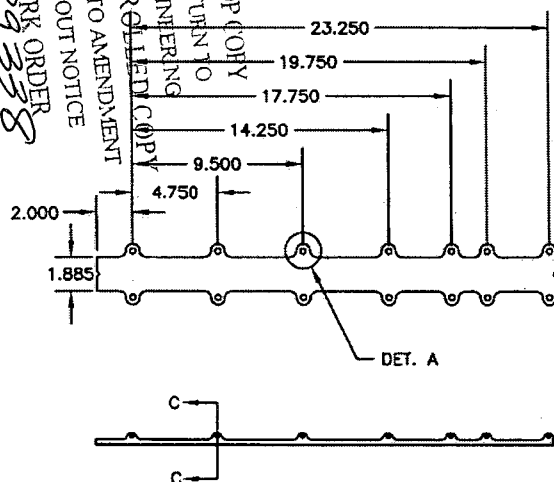
D2656-37



D2656-31



D2656-35



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
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 FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018
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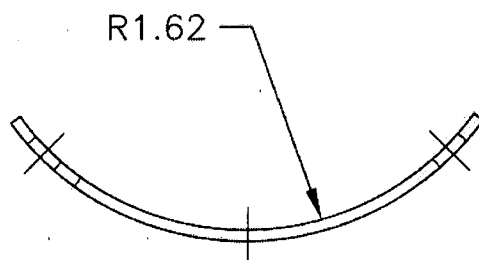
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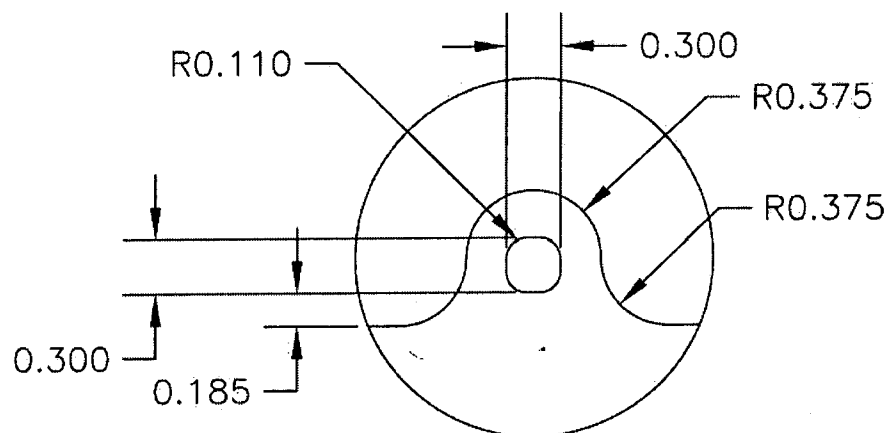
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

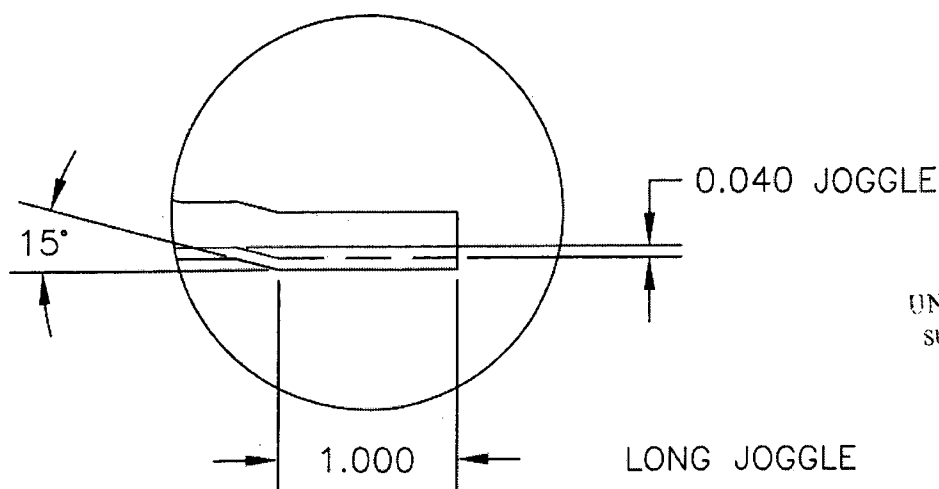


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05.09.06 *[Signature]*

DETAIL A



DETAIL B



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Jason Murdoch

From: S Shahbazian [sshahbazian@dartaero.com]
Sent: Thursday, January 25, 2007 8:20 AM
To: 'L Lacelle'; '*David Shepherd (*David Shepherd)'; 'Peter Hum (Peter Hum)'
Cc: 'Jason Murdoch'
Subject: RE: 1010 STEEL FOR WEARPLATES

I don't see problem of using .029 thicknesses instead of .036 for wearplates, unless David sees a problem.

Thanks
Serge

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: January 25, 2007 8:17 AM
To: 'S Shahbazian'; '*David Shepherd (*David Shepherd)'; 'Peter Hum (Peter Hum)'
Cc: 'Jason Murdoch'
Subject: RE: 1010 STEEL FOR WEARPLATES

Any news on this??

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: January 23, 2007 4:51 PM
To: 'L Lacelle'; '*David Shepherd (*David Shepherd)'; 'Peter Hum (Peter Hum)'
Cc: 'Jason Murdoch'
Subject: RE: 1010 STEEL FOR WEARPLATES

Linda,

Do we know all the variable sizes that those sheets are coming in? The decision to accept the various thicknesses is depending on where the sheets are used. For example in this case it is used for wearplates which I think it is ok; however we have to see where else it will be used. In other words depends on the application.

Thanks
Serge

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: January 23, 2007 10:48 AM
To: '*David Shepherd (*David Shepherd)'; S Shahbazian; Peter Hum (Peter Hum)
Cc: Jason Murdoch
Subject: 1010 STEEL FOR WEARPLATES

We are getting a lot of variances in tolerances on the steel mat'l we purchase for wearplates. Is there a standard tolerance for this mat'l? the 20ga we just rec'd should be about .036 – but we are getting .029 – is this acceptable. We have had this discussion before, but no one came back with a tolerance we can use to check this mat'l. Can anyone help?
LL